

Work Order ID 60952

Thursday, July 29, 2010 7:55:55 AM



Page 1

Item ID:	D2327-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Spacer Bushing				Stop	
Start Date:	7/29/2010	Start Qty:	20.00			
Required Date:	8/5/2010	Req'd Qty:	20.00			
Reference:						

Approvals:	Process Plan:	Date:	7-29	Tooling:	Date:	Run	Start	
	QC:	Date:		SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2327	Rev D								

100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn per Folio FA232 and Dwg D2327 <input type="checkbox"/> Deburr								

SA 10/08/10

20 0

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

SA 10/08/10

20 0

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

SA 10/08/11

20 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

Accept

**Setup Start**

Stop

[illegible]

Abstract

Cust Item ID:

Start Date: 7/29/2010 **Start Qty:** 20.00

Required Date: 8/5/2010 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Abstract

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

0.00

SAD
10-08-11



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00


00000000000000000000

QC

Memo

0.00

Quality Control

10/08/12 

MF
10-8-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, July 29, 2010 7:55:59 AM

Page 1

Work Order ID: 60952

Parent Item: D2327-3

Parent Item Name: Spacer Bushing



Start Date: 7/29/2010

Required Date: 8/5/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP F05.11.02Removed 303 SSKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375 		Purchased	No			100	f	62.7400	0.1563	3.290526			
304 ROUND BAR 0.375													

Location

Loc Qty

Loc Code

MAT

57.4

111323

0

114467

5.1

114676

1.1

115180

3.2

➤ 115334

48

MAT029

5.34

113325

3.85

114356

1.49

3.29 8/10/08/10

W/O:		WORK ORDER CHANGES					
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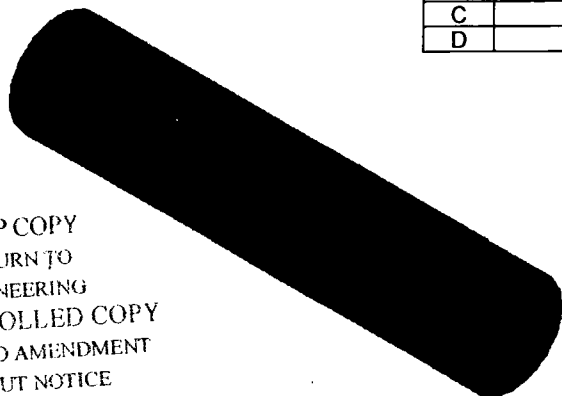
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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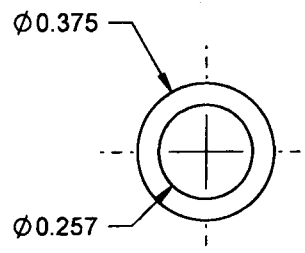
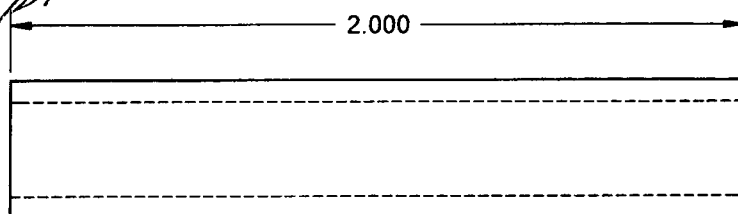


DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED CH	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	

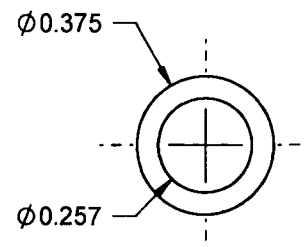
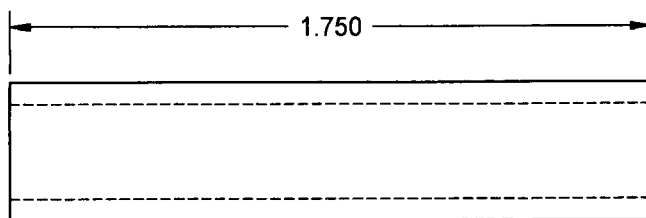


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 00952

06.10-7-29



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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